

Date: Monday, 23/03/2009 9:54:08 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 46648	
Estimate Number : 12740	
P.O. Number :	Part Number : D353523
This Issue : 23/03/2009 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 43406	Material :
Written By :	Due Date : 30/03/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09.03.23</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.4296 sf(s)/Unit Total : 17.1549 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: 110076

M. 09.04.08

(12)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3535
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

m 09.04.08

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 09.04.08

(12)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

09.04.08 (12)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-23

09/04/09 (12)
Form: rprocess

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:54:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 46648

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/09 (17)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1:10

OVEN TEMPERATURE:

~~270~~ 320°

FINISH TIME:

1:40

FL 09/04/09

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-9

(15)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FR-19

BR 09-04-9 12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14 J

Job Completion



mk 09-04-09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44648
Description: Wearshoe		Part Number: D3535-23
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.890	✓		VERN	
2.000	+/-0.010	2.000	✓		M.T	
4.750	+/-0.010	4.750	✓		M.T	
9.500	+/-0.010	9.500	✓		M.T	
14.250	+/-0.010	14.250	✓		M.T	
17.750	+/-0.010	17.750	✓		M.T	
23.140	+/-0.010	23.140	✓		M.T	
28.530	+/-0.010	28.530	✓		M.T	
33.920	+/-0.010	33.920	✓		M.T	
39.310	+/-0.010	39.310	✓		M.T	
44.700	+/-0.010	44.700	✓		M.T	
48.200	+/-0.010	48.200	✓		M.T	
52.850	+/-0.010	52.850	✓		M.T	
Ø0.188	+0.005/-0.001	0.190	✓		VERN	
48.00	+/-0.030	48.00	✓		M.T	
39.00	+/-0.030	39.00	✓		M.T	
32.00	+/-0.030	32.00	✓		M.T	
24.00	+/-0.030	24.00	✓		M.T	
16.00	+/-0.030	16.00	✓		M.T	
8.00	+/-0.030	8.00	✓		M.T	
6.00	+/-0.030	6.00	✓		M.T	
0.300	+/-0.010	0.302	✓		VERN	
0.300	+/-0.010	0.302	✓		VERN	
0.038	+/-0.010	0.039	✓		VERN	

Measured by: M.M
Date: 09-04-08

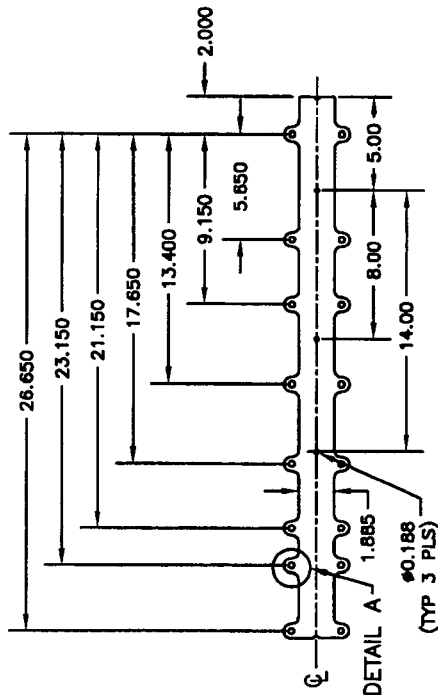
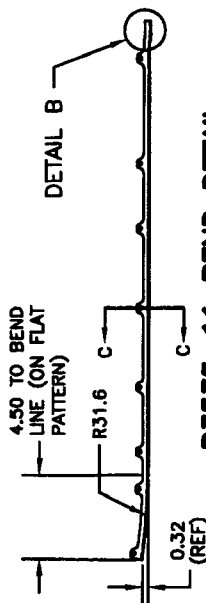
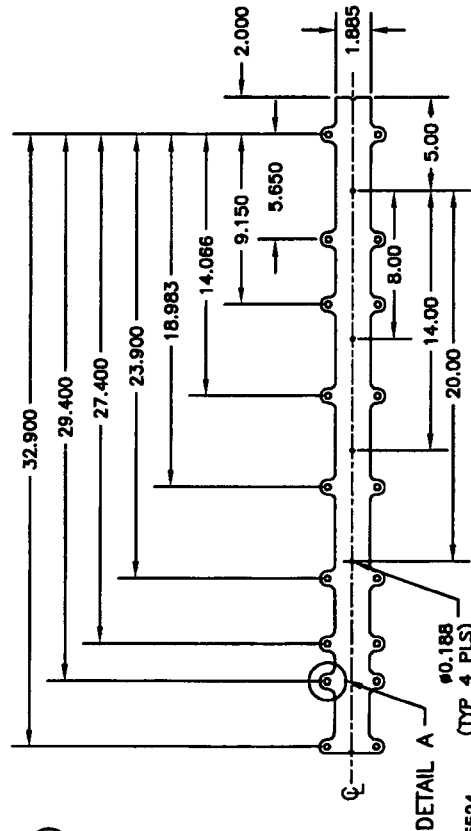
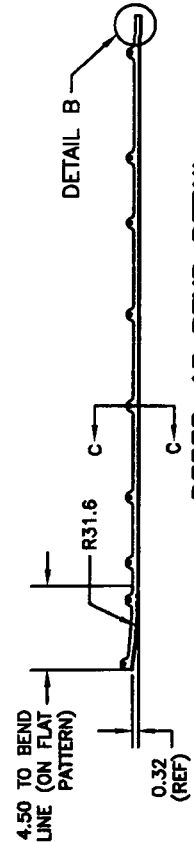
Audited by: [Signature]
Date: 16-04-08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	[Signature]

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 1 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

RELEASED07.04.24 *[Signature]***D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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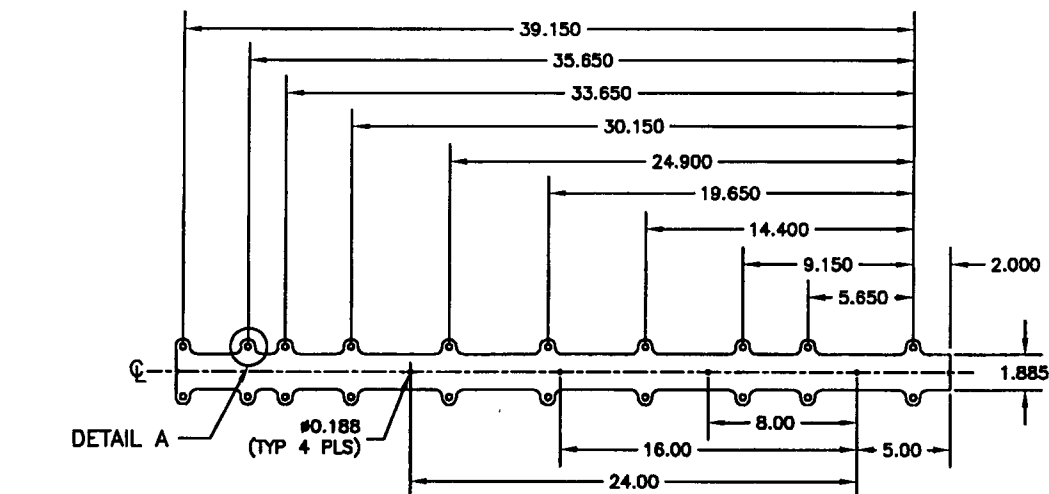
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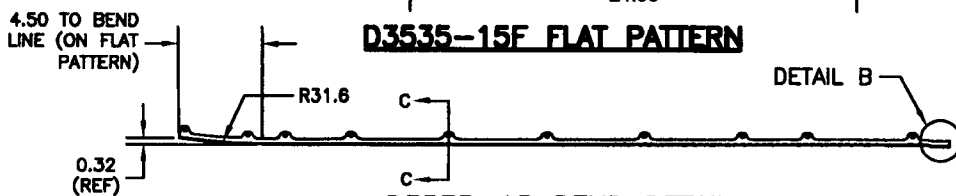
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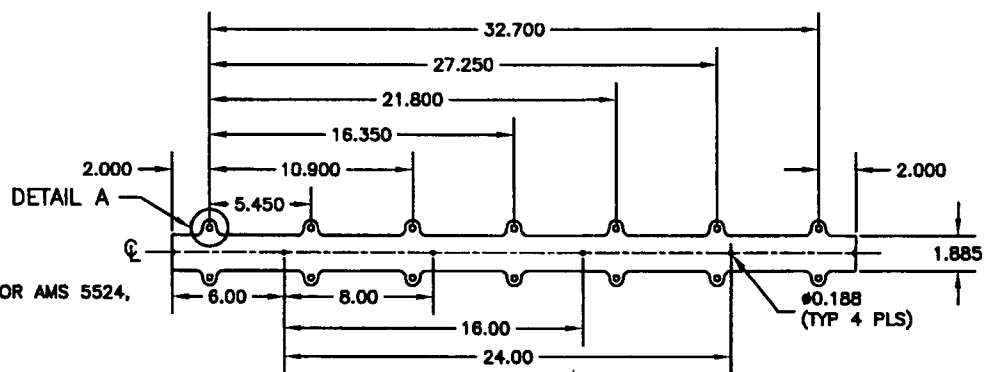
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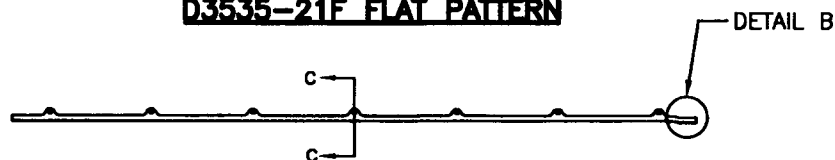
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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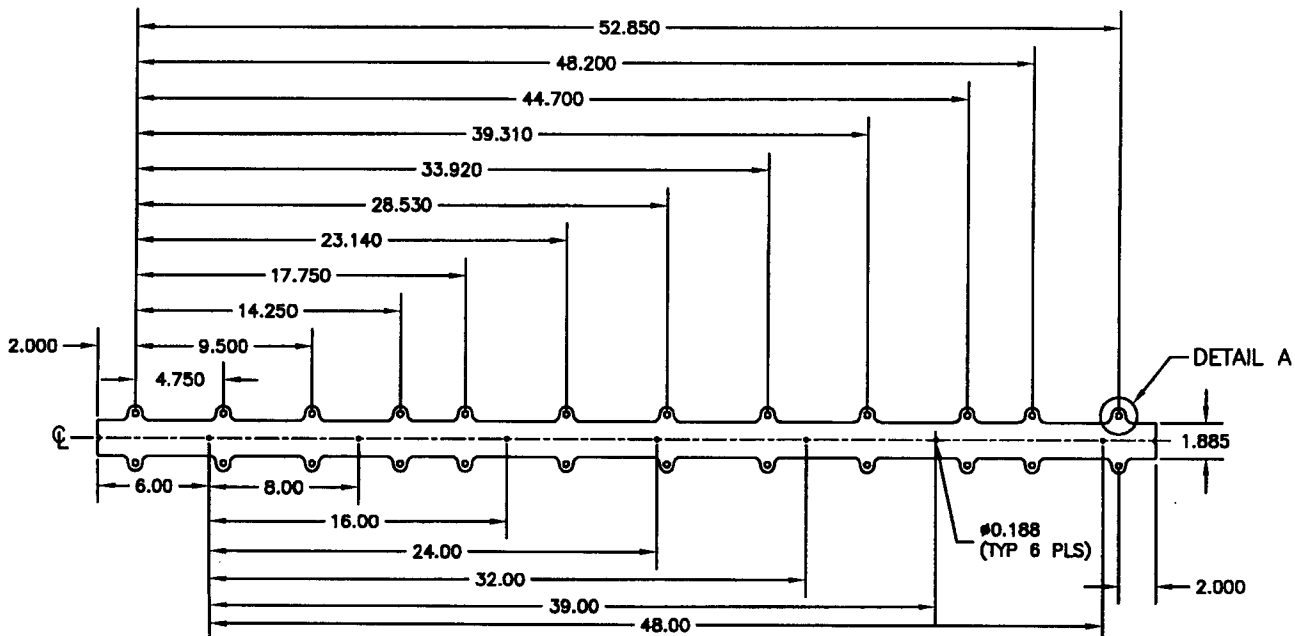
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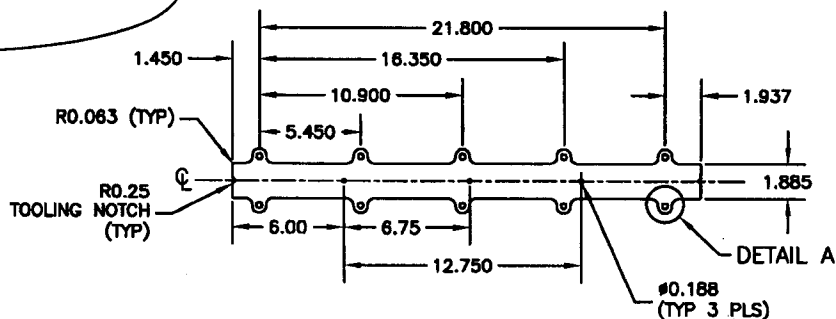
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TITLE	WEARSHOE	SHEET	3 OF 7	SCALE
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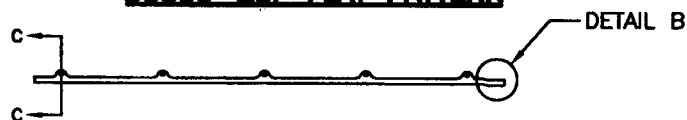
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D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

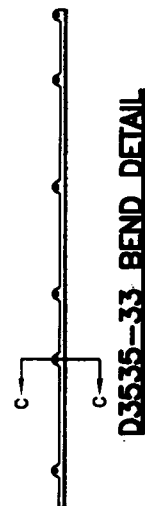
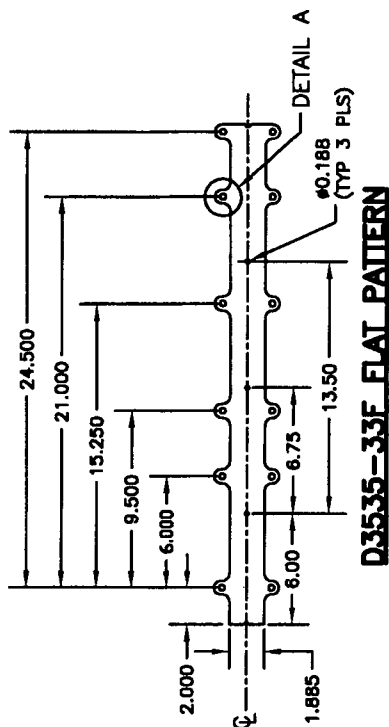
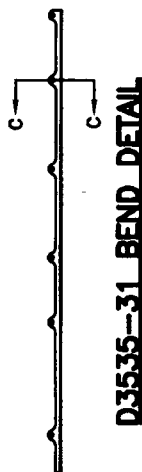
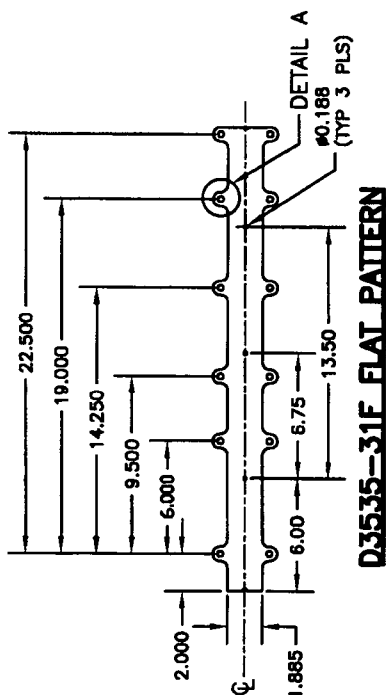
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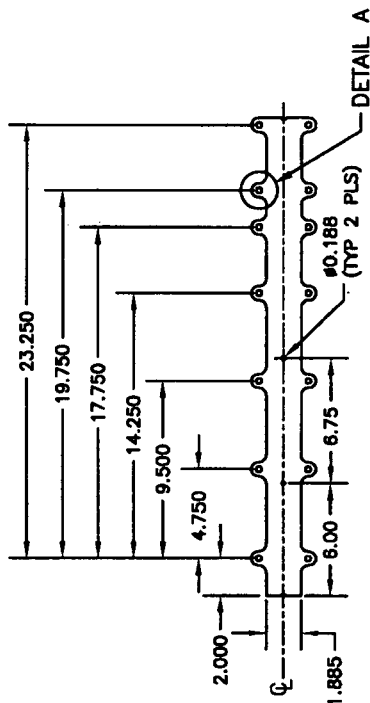
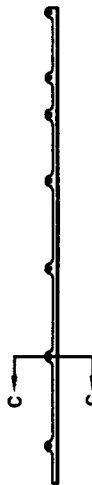
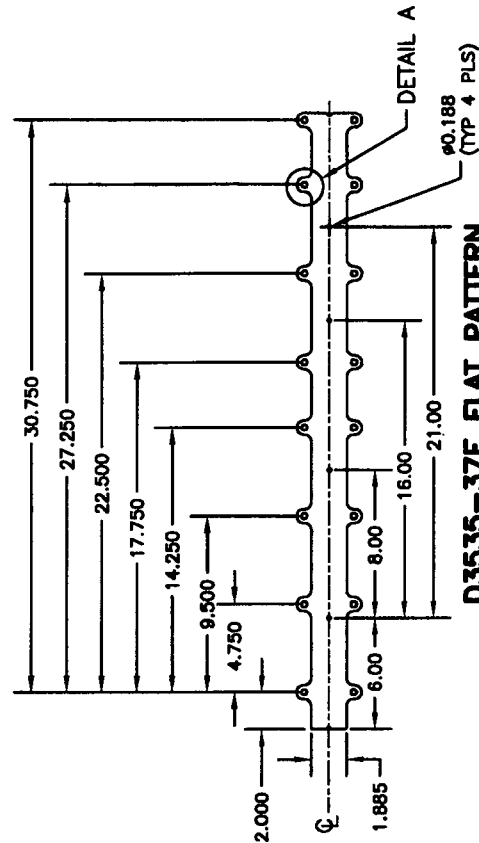
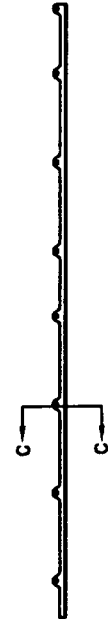
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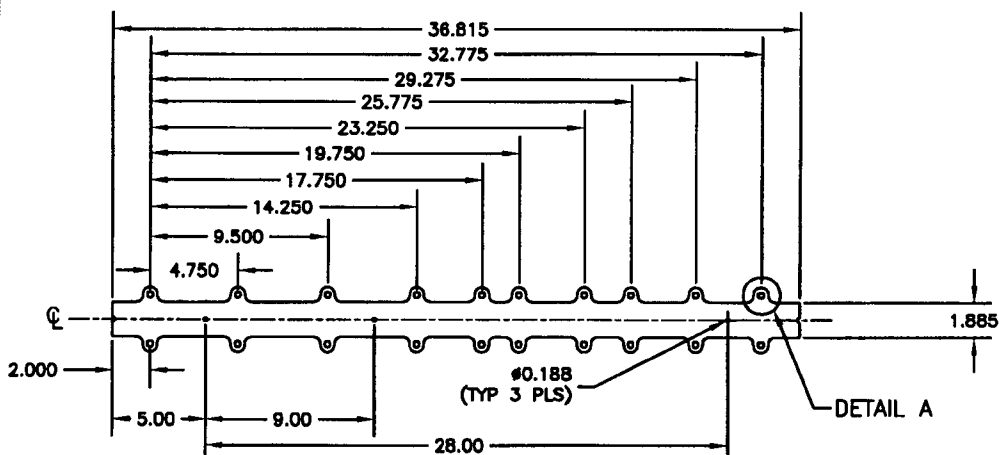
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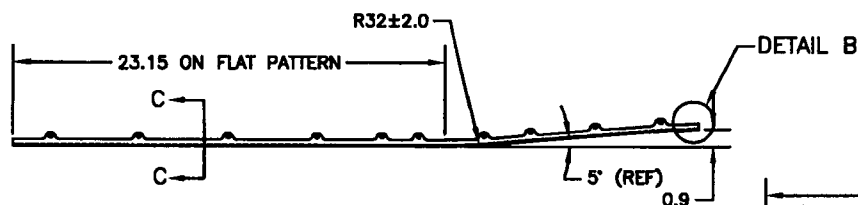
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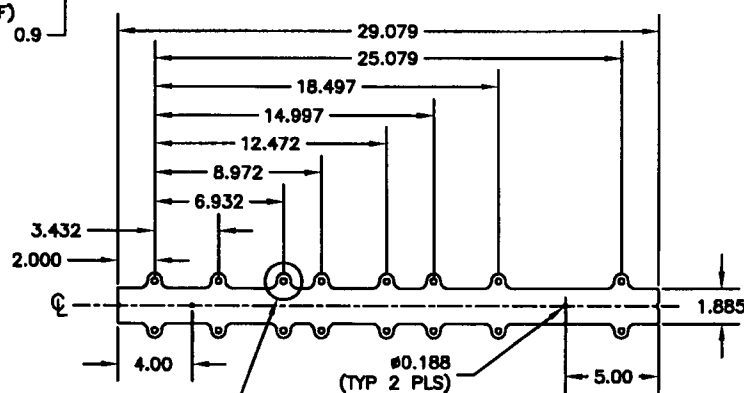
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DATE	TITLE	WEARSHOE	SCALE
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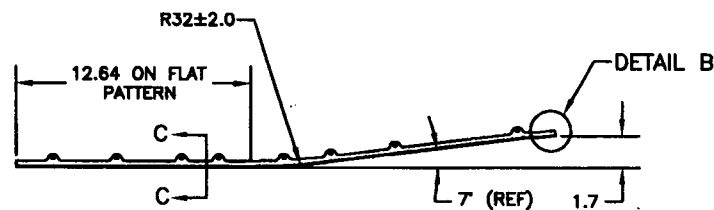
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN

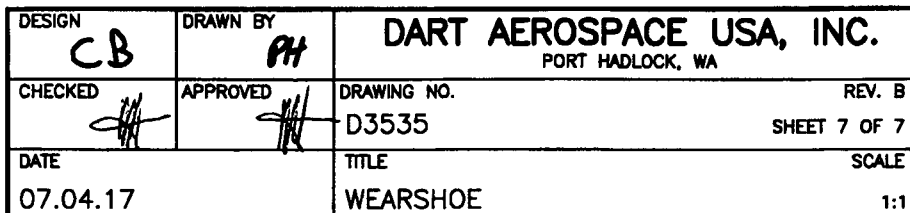


D3535-41 BEND DETAIL

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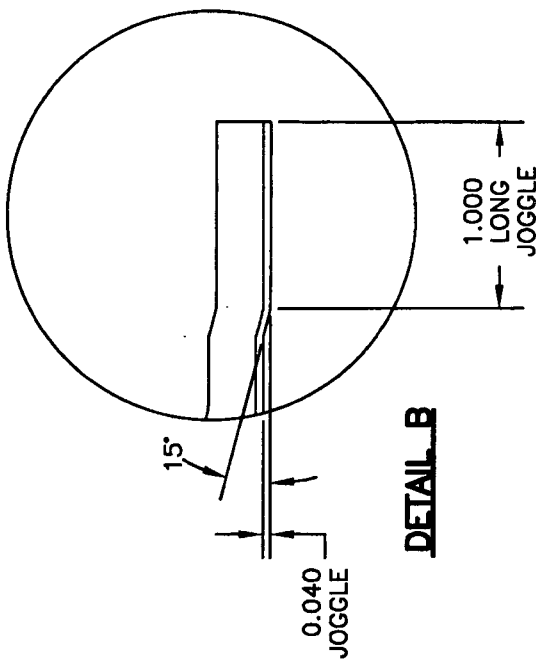
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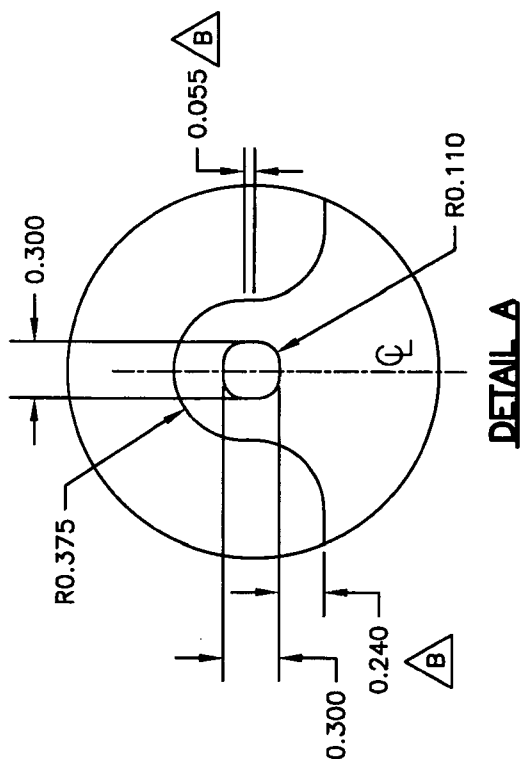


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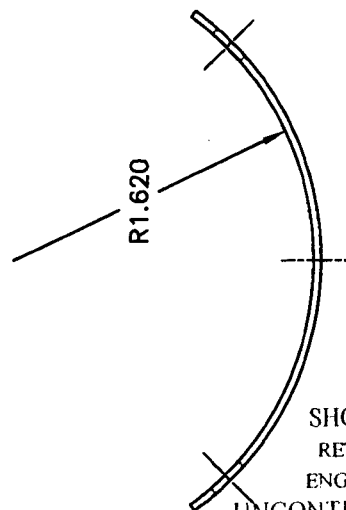
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DETAIL B



DETAIL A



SECTION C-C

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